

Date: Wednesday, 3/7/2007 8:35:08 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 31026	
Estimate Number : 12776	
P.O. Number :	Part Number : D2127251921
This Issue : 3/7/2007 S.O. No. :	Drawing Number : D212-725-1 UNDER REV
Prsht Rev. : NC	Project Number : N/A
First Issue : 3/6/2007 Type : SMALL /MED FAB	Drawing Revision : UR B <i>Just</i>
Previous Run :	Material :
Written By : <i>07-03-07</i>	Due Date : 3/13/2007 Qty: 4 Um: Each
Checked & Approved By : <i>07-03-07</i>	
Comment : Est Rev: A New Issue 07-03-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR0750W049	304 RD Tube .750 x .049W
-----	----------------	--------------------------



Comment: Qty.: 1.8375 f(s)/Unit Total : 7.3500 f(s)

304 RD Tube .750 x .049W

Batch: *M102273*

FO 07-03-07

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Form as per Dwg D212-725-1 & Template DT6911

Cancelled
No issues from Prod Eng.

3.0	AN81812J	Nut
-----	----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: *M1238*

4.0	MS2081912J	Sleeve
-----	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Sleeve

Batch: ~~M102273~~ *M1819*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Flare ends as per Dwg D212-725-1

Ensure to install sleeves and nuts before flaring*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:35:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 31026

Part Number: D2127251921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



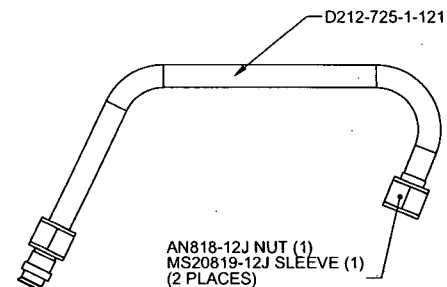
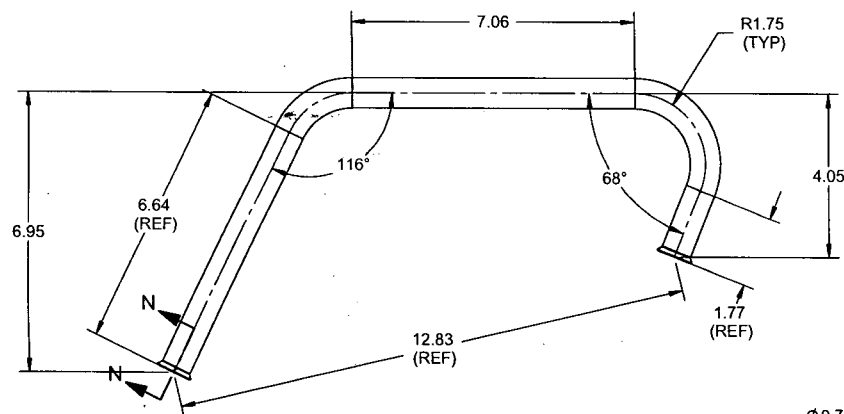
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

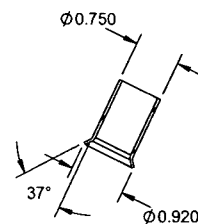
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D212-725-1-921 TUBE ASSEMBLY



SECTION N-N
(FINISH FLARE ONE END
AFTER ASSEMBLY)
SCALE 1:2

D212-725-1-121 TUBING
MANUFACTURE PER TEMPLATE DT8911

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31026

NOTES:

- 1) MATERIAL: AISI 304/316 SS Ø0.750 x 0.049 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D212-725-1-921 USING FINE POINT PERMANENT INK MARKER

B	07.03.02	ADD D212-725-1-921	
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. B SHEET 39 OF 41
DATE 07.03.02	TITLE 212S DETAIL PARTS		SCALE 1:3
COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			